

Date: Monday, 11/12/2007 11:45:58 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	HI-STEP LEG ASSEMBLY
Job Number	35622		
Estimate Number	10385		
P.O. Number	N/A	Part Number	D3065041
This Issue	11/12/2007	S.O. No.	N/A
Prsht Rev.	NC	Drawing Number	D3065 REV B
First Issue	N/A	Project Number	N/A
Previous Run	33510	Drawing Revision	B
Written By		Material	N/A
Checked & Approved By		Due Date	11/30/2007
Comment	Est Rev: C 02.11.01	Incorporated D3066-1 IPP KJ/RF	Qty: 50 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:	
1.0	D30651	Step Spacer	
		Comment: Qty.: 1.0000 Each(s)/Unit Total: 100.0000 Each(s)	50
		Step Spacer	
2.0	D30653	Step Spacer	
		Comment: Qty.: 1.0000 Each(s)/Unit Total: 100.0000 Each(s)	50
		Step Spacer	
3.0	D30655	Step Leg	
		Comment: Qty.: 2.0000 Each(s)/Unit Total: 200.0000 Each(s)	100
		Step Leg	
4.0	D30657	Step Spacer	
		Comment: Qty.: 1.0000 Each(s)/Unit Total: 100.0000 Each(s)	50
		Step Spacer	
5.0	MS20470AD44	Rivet, Universal Head	
		Comment: Qty.: 30.0000 Each(s)/Unit Total: 900.0000 Each(s)	1500
		Rivet, Universal Head	
		Pick:	
	Qty	Part Number	Description
	30	MS20470AD4-4	Rivet
			Batch
			m105108
			1500 mf 08-01-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: AD Date: 08/01/11
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/12/2007 11:45:58 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HI-STEP LEG ASSEMBLY

Job Number: 35622

Part Number: D3065041

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3065 and Identify as D3065-041

MF 08-01-07

50

7.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/01/07 X 50

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WA

08.01.09 50

9.0 QC21

FINAL INSPECTION/W/O RELEASE



50

Comment: FINAL INSPECTION/W/O RELEASE

08/01/11

Job Completion



2008/1/10
W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

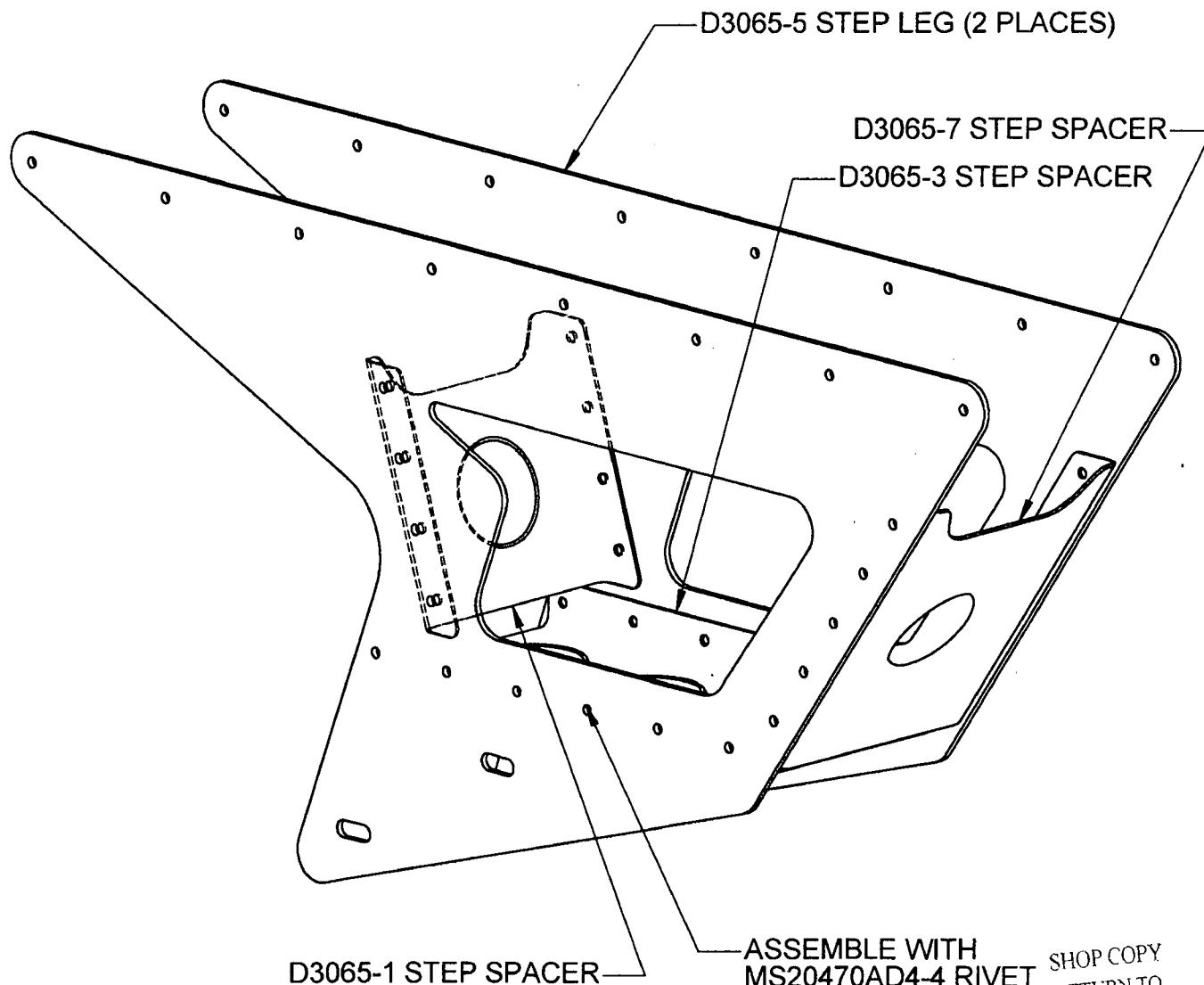
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
	PH	D3065	SHEET 1 OF 5
DATE	06.05.23	TITLE	SCALE
		STEP LEG ASSEMBLY	1:2
A	02.09.11	NEW ISSUE	
B	06.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5	

RELEASED06.06.20 ~~CH~~**D3065-041 STEP LEG ASSEMBLY**

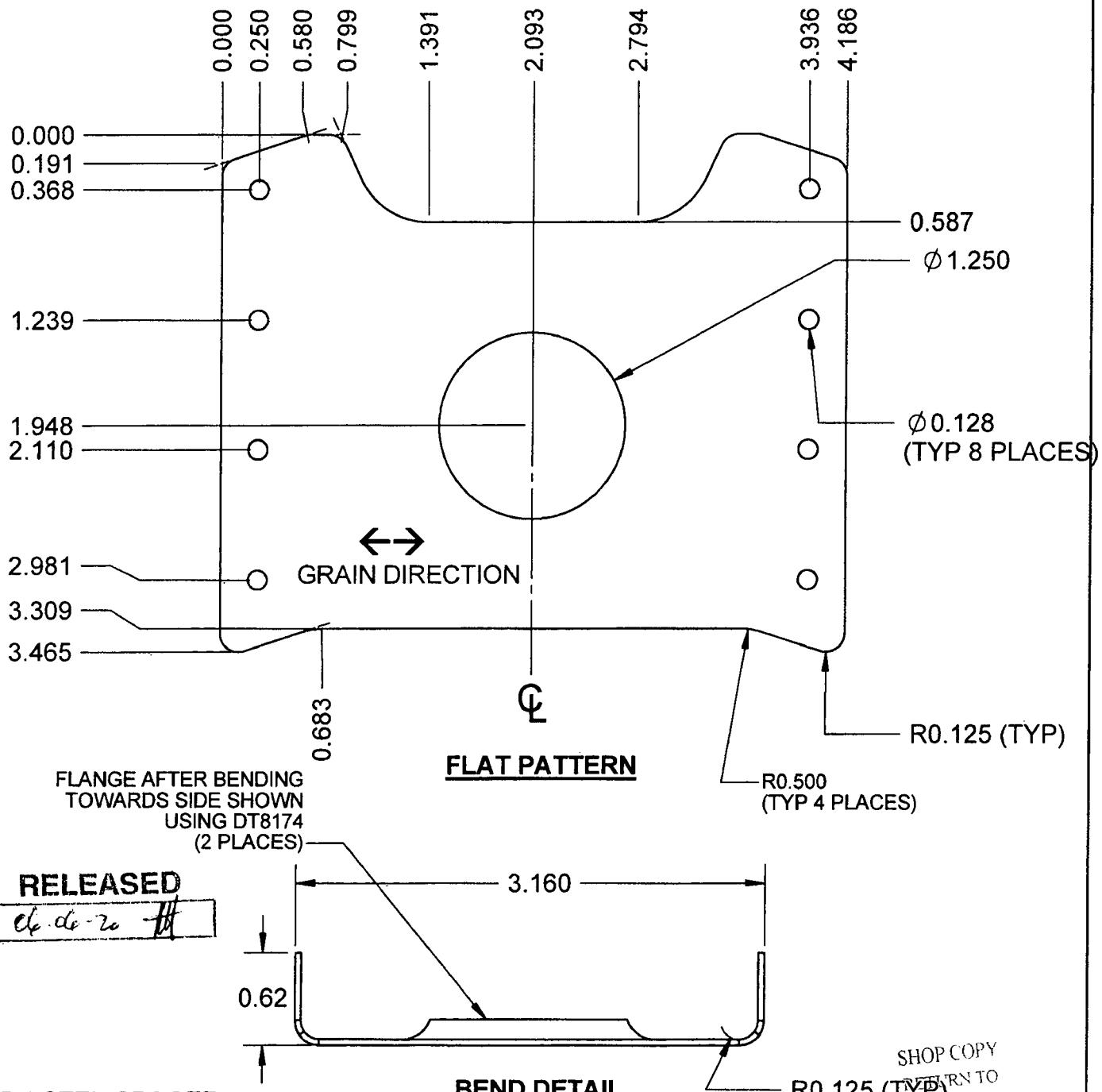
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PH		D3065	SHEET 2 OF 5
DATE	06.05.23	TITLE	SCALE
		STEP LEG ASSEMBLY	1:1

**D3065-1 STEP SPACER**

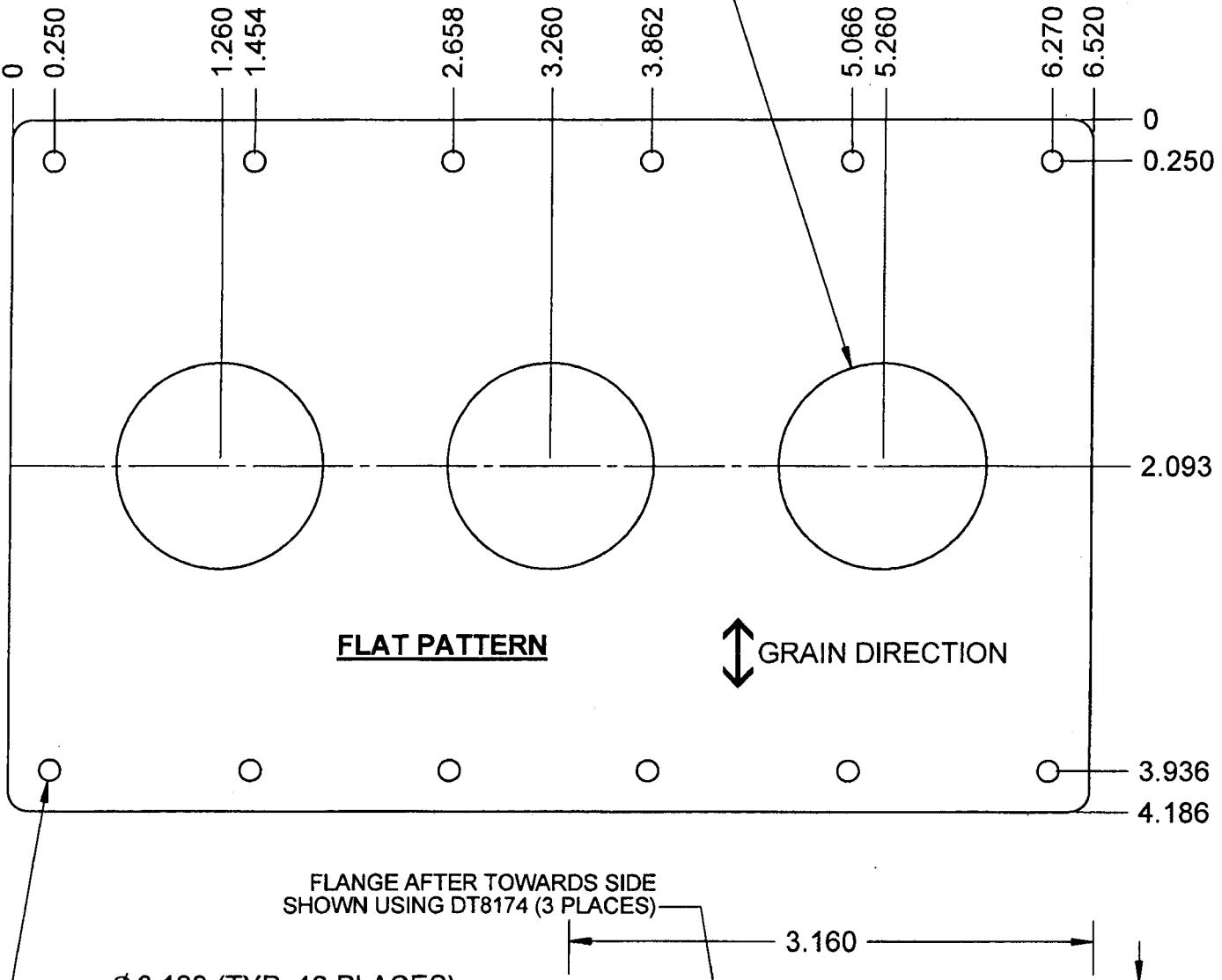
- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S-040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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CHECKED <i>PH</i>	APPROVED <i>MM</i>	DRAWING NO. D3065	REV. B	SHEET 3 OF 5
DATE 06.05.23	TITLE STEP LEG ASSEMBLY	SCALE 1:1		

 $\phi 1.250$ (TYP, 3 PLACES)**D3065-3 STEP SPACER**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4)
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

BEND DETAIL

R0.125

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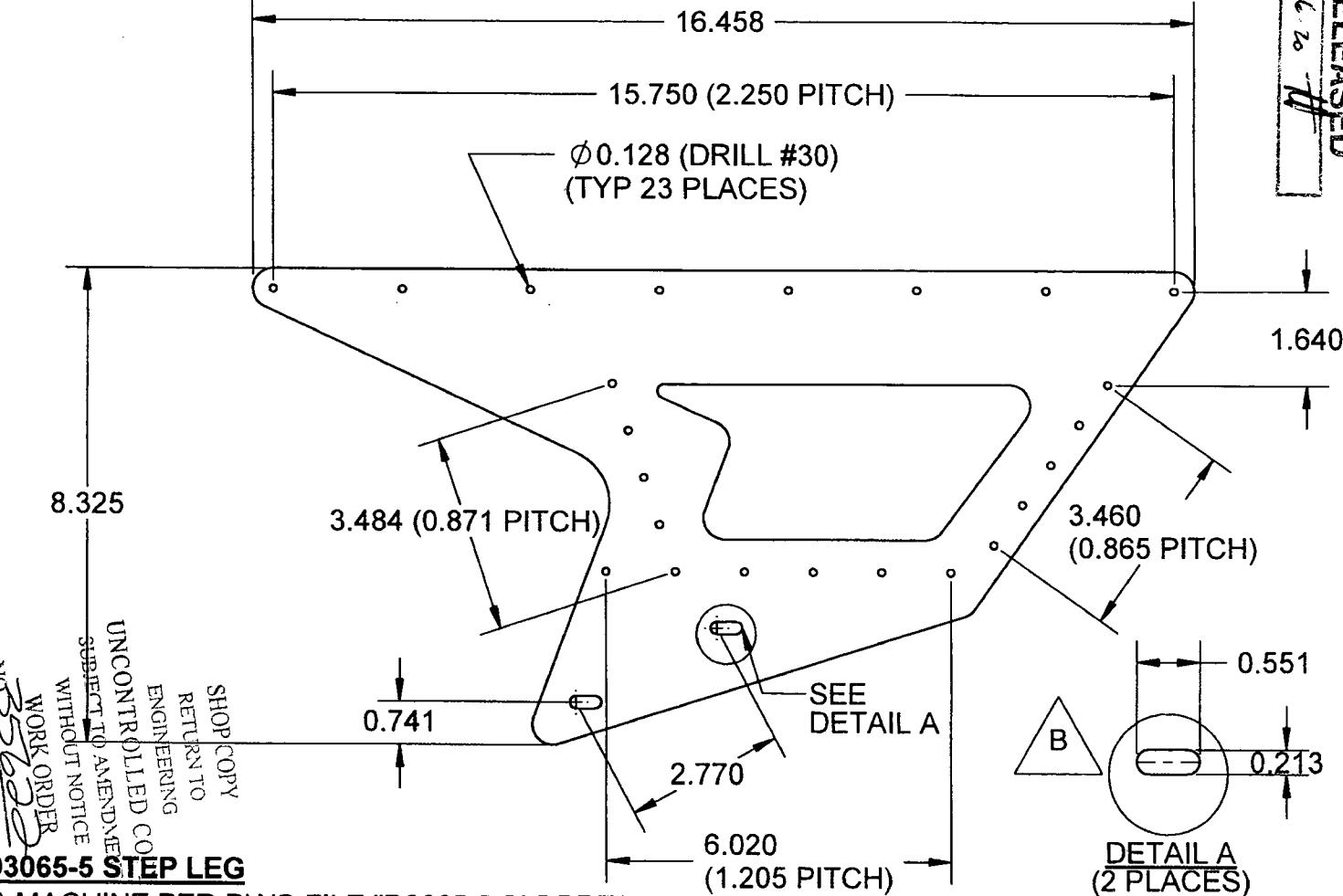
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DESIGN <i>10</i>	DRAWN BY <i>C.B.</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO CANADA
CHECKED <i>PH</i>	APPROVED <i>JK</i>	DRAWING NO. <i>D3065</i>
DATE <i>06.05.23</i>	TITLE <i>STEP LEG ASSEMBLY</i>	REV. B SHEET 4 OF 5 SCALE 1:3

RELEASED
06.06.20NO *2522***D3065-5 STEP LEG**

- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
- 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080)
OR
5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

DART

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CHECKED <i>PH</i>	APPROVED <i>CH</i>	DRAWING NO. D3065	REV. B SHEET 5 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1

